



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4635-2
Job Sheet 185093



Part No: D4635-2

Job Qty: 1 ea

Part Name: Fwd Ceiling Panel, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F SHEETS 14,17,18 IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg.
Update 12/11/08 DL IPP Rev C Dwg. Update 13/07/09 DL IPP Rev D Dwg. Update, Material Change 13/12/18
DL IPP Rev. E Dwg. Update 14/01/09 DL IPP Rev. F Dwg Update 15/01/27

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	4 pcs	11/16/18	11/16/18	0.00	0.00	Purchasing		DEC 03 2018
140	Packaging	4 pcs	11/16/18	11/16/18	0.00	0.00	Packaging2		DEC 03 2018
150	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC6		38AS
170	Packaging	4 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3	816231 JAN 11 2019	9-85
180	QC21-SA	4 Ea	11/16/18	11/16/18	0.00	0.00	QC21		9-89

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs
Descriptions: 150 - QC6- All purchased or subcontracted products
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

DAG
21
9-89

JAN 14 2019

PO041442 oct 24. 2018 x4 Rh

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-2P	Fwd Ceiling Panel, RH	4 pcs (1 ea)	110-Purchasing	5134112
MLEXS.093-F6006-07	GE Plastics Lexan Sheet (Light Grey)	101.0800 sf (25.27 ea)	110-Purchasing	5134123

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D4635-2P	4	3	0
	MLEXS.093-F6006-07	101	1,735	0

Part Specifications

uld not be found.

Plex 10/22/18 2:38 PM Dart.lajeunesse.marie



Container No: S134129



Part: D4635-2

Job No: 185093

Serial No/Batch: S134129

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/03/18

DQA: _____ Date: _____

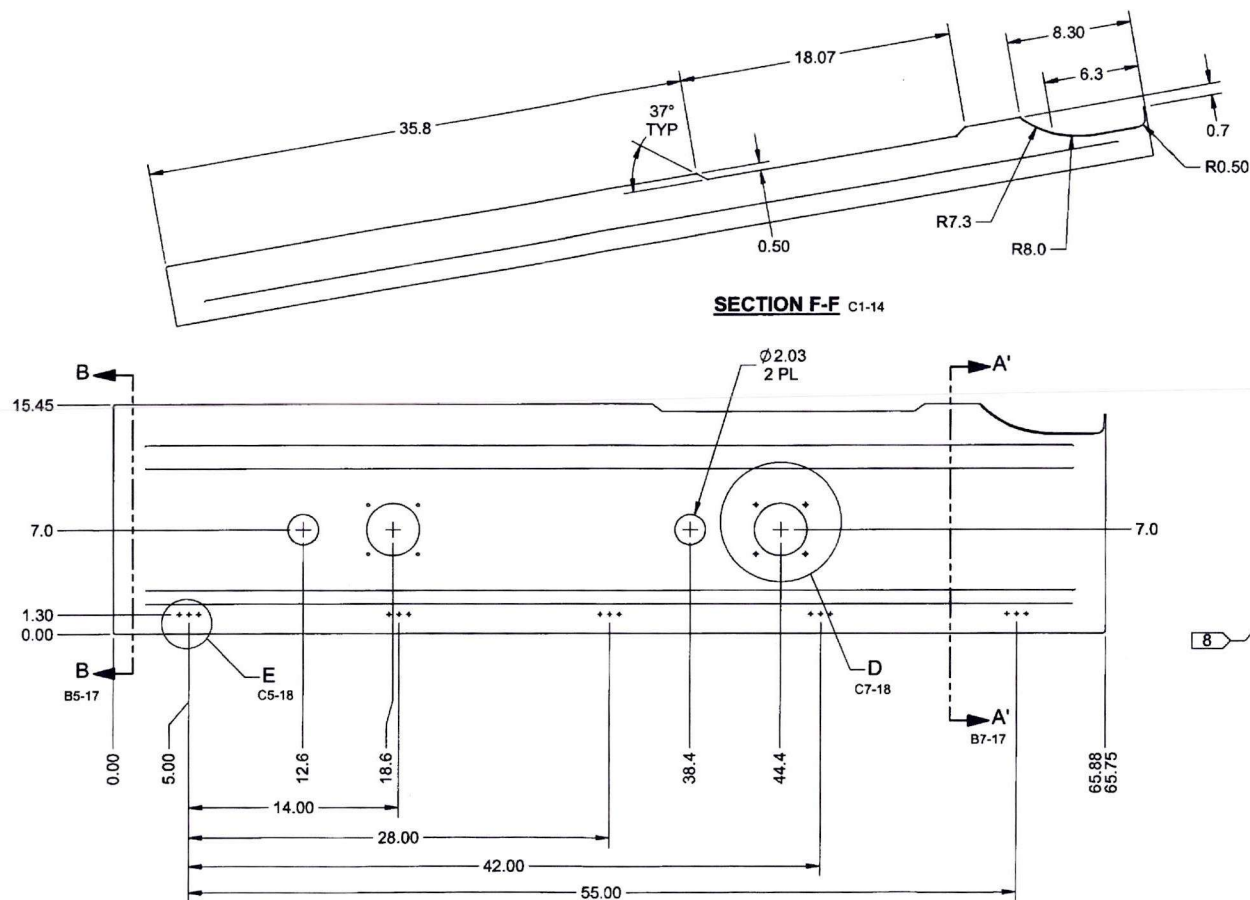


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185093 MCL
187022

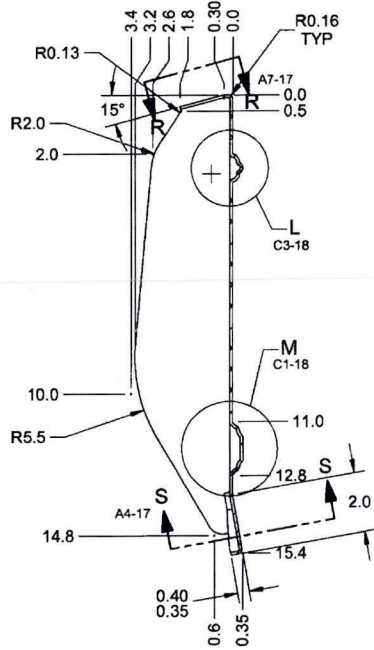
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.37 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-2 PER TOOL DT9840
- 10) THERMOFORM D4635-2 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-2 RH, FWD CEILING PANEL

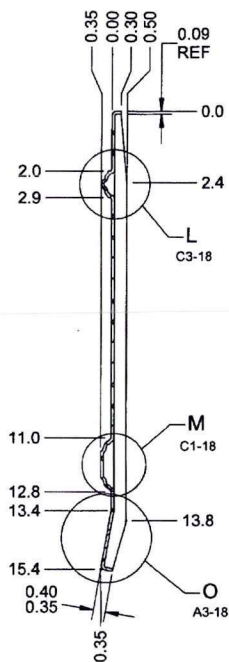
RELEASED
2015 JAN 26

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	DRAWN	RF		
	CHECKED	AK	DRAWING NO.	REV. F
	MFG. APPR.	DL	D4635	SHEET 14 OF 18
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
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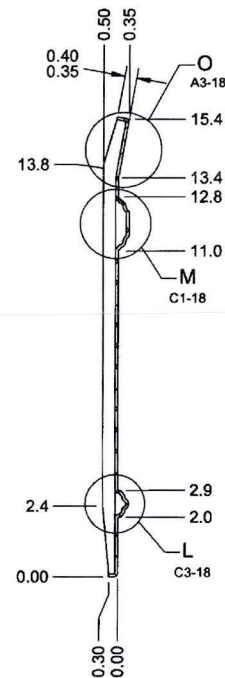
SECTION A-A
SECTION A-A' OPPOSITE
SCALE 2X

B3-13
B3-14



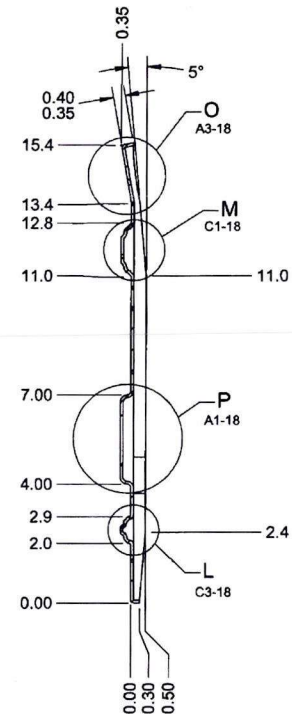
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B7-13
B7-14



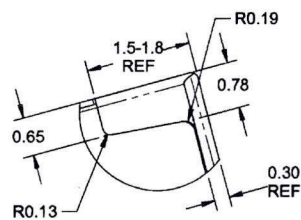
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B4-15
B4-16



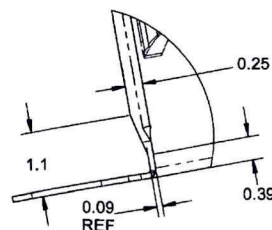
SECTION K-K
SCALE 2X

C6-16



AUXILIARY VIEW R-R
SECTION R-R' OPPOSITE
SCALE 2X

D7-17



AUXILIARY VIEW S-S
SECTION S-S' OPPOSITE
SCALE 2X

B7-17

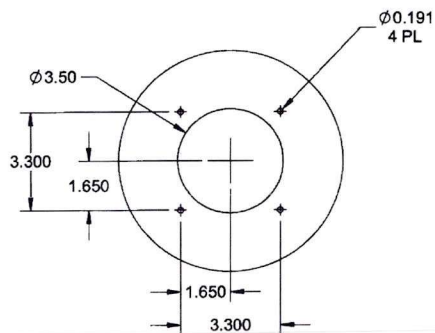
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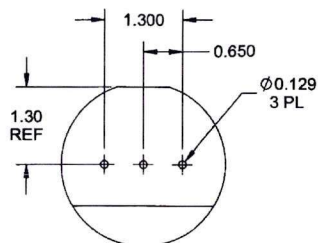
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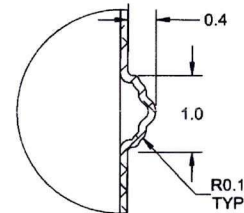
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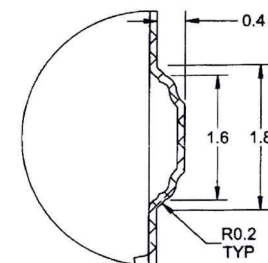
DETAIL D
SCALE 2X
B4-13
B3-14
B5-15
B5-16



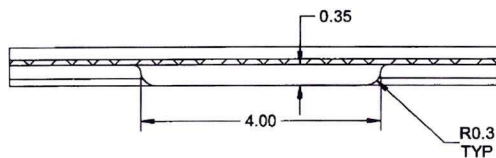
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C7-13
B6-14
C6-15
B5-16



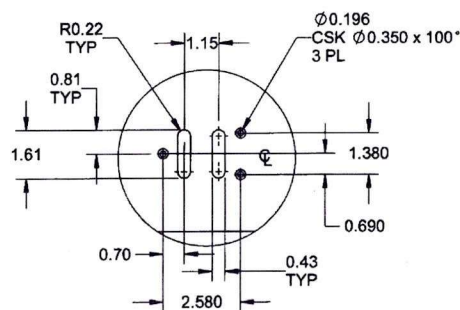
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SCALE 1.5X
B2-17
B4-17
C5-17
C7-17



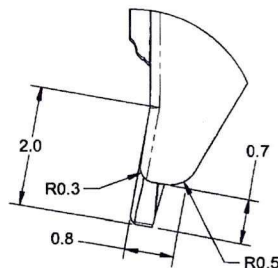
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C3-17
C5-17
C7-17



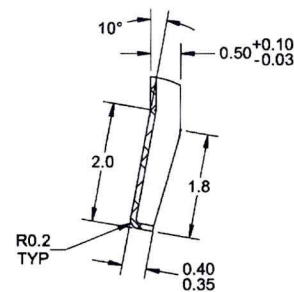
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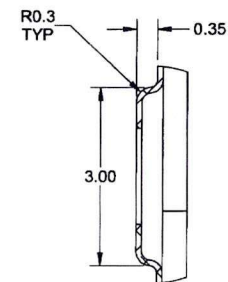
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SCALE 2X
C5-16



DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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2015 JAN 26

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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 18 OF 18
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8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041442**

Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: PO041442
PO Date: 10/24/18
Due Date: 11/21/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185086	D4635-1P			Fwd Ceiling Panel, LH : Various STC's As Per Dwg D4635 Rev. F	Firmed	-	11/21/18	3 pcs	0 pcs	3 pcs	\$225.00/pcs	\$675.00
							3x	NOV 26 2018					
3	185093	D4635-2P			Fwd Ceiling Panel, RH : Various STC's As per Dwg D4635 Rev. F	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
							5x	DEC 03 2018					
8	187022	D4635-1P			Fwd Ceiling Panel, LH : Various STC's As Per Dwg D4635 Rev. F	Firmed	-	11/26/18	2 pcs	0 pcs	2 pcs	\$225.00/pcs	\$450.00
							2x	DEC 03 2018					
Grand Total:												\$2,250.00	

DAS
38
9-89

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Packing Slip

Shipment Number: 32706
Shipment Date: 11/30/2018
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: DALE BATES
O Buyer Contact: PATRICK LUSSIER

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: PATRICK LUSSIER
O

Purchase Order
41442 ✓
Carrier Account #
151793240

Sales Order
SO-026069

Incoterms
EX WORKS

Ship Via
FEDERAL EXPRESS - Ground

Payment Method
COL
Tracking Number
773842875437

Item Number
Revision

Description

Quantity
Shipped UOM

D4635-1 - Rev.: F ✓ FWD CEILING PANEL, LH
AS PER DWG D4635 REV. F
D4635-2 - Rev.: F ✓ FWD CEILING PANEL, RH
AS PER DWG D4635 REV. F

2 ✓ EA
5 ✓ EA

DAE
38
9-89

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD

P.O. # 41442

SO # 026069

Part #	<u>D4635-1</u>	Qty.	<u>2</u>	Batch #	<u>-001</u>
Description	<u>FWD CEILING PANEL, LH</u>	Material usage	<u>3 SHEETS</u>	Lot#	<u>DART0116</u> <u>0007424014</u>
Part #	<u>D4635-2</u>	Qty.	<u>5</u>	Batch #	<u>-002</u>
Description	<u>FWD CEILING PANEL, RH</u>	Material usage	<u>11 SHEETS</u>	Lot#	<u>DART0116</u> <u>0007424014</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AS
(Approved QA Signatory)

Date: Nov. 30, 2018 C OF C # 094

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com